

5164469



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-253
Job Sheet 191900



Part No: D135-1027-253

Job Qty: 1 pcs

Part Name: Mid Height Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/19

Job Tracking No:

Due Date: 3/22/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D135-1027-253 REV.C IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 18.01.02 AS PER DWG
REV.B DD VERF:JFS IPP REV:C 18.11.09 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Handfinish - 1 - Chemical	1 pcs	3/22/19		0.00	0.17	Handfinish - 1 - 1	
							Handfinish - 1 - 2	
							Handfinish - 1 - 3	
							Handfinish - 1 - 4	
							Handfinish - 1 - 5	
							Handfinish - 1 - 6	
							Handfinish - 1 - 7	
							Handfinish - 1 - 8	
							Handfinish - 1 - 9	
							Handfinish - 1 - 10	
							Handfinish - 1 - 11	
							Handfinish - 1 - 12	
							Handfinish - 1 - 13	
							Handfinish - 1 - 14	
							Handfinish - 1 - 15	
							Handfinish - 1 - 16	
							Handfinish - 1 - 17	
							Handfinish - 1 - 18	
							Handfinish - 1 - 19	
							Handfinish - 1 - 20	
							Handfinish - 1 - 21	
							Handfinish - 1 - 22	
105	QC 7	1 pcs	3/22/19		0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S164469



Part: D135-1027-253

Job No: 191900

Serial No/Batch: S164469

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 03/21/19

3/12/2019

[Dart Hawkesbury] Job Sheet - Lussier, Patrick

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
110 Purchasing	1 pcs	3/22/19	0.00 0.00		Purchasing - 1	03/21/2019 PL
10 9-89 Outsource 23					Purchasing - 2	
					Purchasing - 3	
120 Packaging 2-1 - Receive - B4B	1 pcs	3/22/19	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130 QC 6	1 pcs	3/22/19	0.00 0.00		QC 6 - 42	
					QC 6 - 9	PD 19-03-25

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				QC 6 - 68		
				QC 6 - 61		
132	Crosstubes - 2 - B4B	1 pcs	3/22/19	0.00 1.00	Crosstubes - 1 - B4B	4/4/2019
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
135	QC 5	1 pcs	3/22/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	PD 12.04.04
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
140	Outsource	1 pcs	3/22/19		SKY002-VC	PO043076 APR 08 2019
150	Packaging 2-2 - Receive - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
						Plex 3/12/19 9:00 AM dart.Lussier.Patrick

DAS
13
9-89

160 QC 6	1 pcs	3/22/19	0.00 0.00	Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	APR 11 2019 68
170 Packaging 3-1 - Stock - B4B	1 pcs	3/22/19	0.00 0.00	QC 6 - 61	9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - FG	1 pcs	3/22/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	APR 11 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - (Chemical Conversion Coat per QSI005 4.1) Alodine prior to sending the extrusion to an outside vendor.
 Descriptions: 105 - (QC7-Inspect Chemical Conversion Coat)
 110 - (Purchasing) Issue P/O to Tube Caron: 042567 Manufacture D135-1027-253 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6027-115** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material release note is attached
 130 - (QC6- All purchased or subcontracted products)
 132 - (Crosstube Grinding Booth) REMOVE ALL MARKS AS PER DWG
 135 - (QC5- Inspect part completeness to step on W/O)
 140 - ISSUE P/O: _____ C OF C IS REQUIRED
 150 - (Receive & Inspect for Damage & Mat'l Certs) C OF C IS REQUIRED
 160 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6027-115	Crosstube Material	1 Ea (1 ea)	100-Handfinish - 1 - Chemical	5152382
D135-1027-253P	Mid Height Aft Crosstube	1 pcs (1 ea)	120-Packaging 2-1 - Receive - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Handfinish - 1 - Chemical	D6027-115	1	49	0
120-Packaging 2-1 - Receive - B4B	D135-1027-253P	1	11	0

Part Specifications

Specifications could not be found.

Plex 3/12/19 9:00 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Supplier: TUB001-VC
Tube Caron Inc.
99 Louis-Joseph-Doucet Street
Lanoraie
QC
JOK 1EO Canada
Phone: 450-887-2766
Fax: 450-887-2897

PO No: PO042567
PO Date: 2/11/19
Due Date: 3/22/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190567	D135-1027-253	Mid Height Aft Crosstube (Purchasing) Issue P/O to Tube Caron: Manufacture D135-1027-253 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6027-115** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

1X MAR 21 2019

Line Item Note REV C

	190568	1X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
DAS	190569	1X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
9	191900	1X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
9-89	191901	1X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5	\$1,500.00



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PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	190489	D135-1027-251	Std Height Aft Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
<i>1 X</i> MAR 21 2019											
Line Item Note REV D											
	190571	<i>1 X</i>	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	190572	<i>1 X</i>	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191903	<i>1 X</i>	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191905	<i>1 X</i>	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191907	<i>1 X</i>	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							6	0	6		\$1,800.00



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PURCHASE ORDER

PO042567



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190560	D135-1027-153	Mid Height Fwd Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note REV B											
	190562		1 X MAR 2 1 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	190564		1 X MAR 2 1 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191909		1 X MAR 2 1 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191910		1 X MAR 2 1 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5		\$1,500.00



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	190575	D135-1027-151	Std Height Fwd Crosstube Purchasing - Issue P/O to Tube Caron: Manufacture D135-1027-151 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note REV D 190576 1 X MAR 21 2019 191908 1 X MAR 21 2019 Sub Total: 3 0 3 \$900.00											

Grand Total: \$5,700.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/21/19 12:52 PM dart.Lussier.Patrick

**SHIPPING BILL****BOL 14944****13/03/2019****Tube Caron Inc.**

99 Louis-Joseph-Doucet
Lanoraie, QC, Canada
J0K 1E0
Phone: 450-887-2766

Fax: 450-887-2897

Ship To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-1053

Fax : 613-632-4443

Sold To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-5200

Fax : 613-632-4443

Third Party Billing:

Ln	Item	Qty	Po	Job	Weight	UOM
1	PALETTE	1			20.00	Pounds
	D135-1027-151 REV D	1	✓ PO042567	J21867-11	13.36	Pounds
	D135-1027-151 REV D	1	✓ PO042567	J21867-12	13.36	Pounds
	D135-1027-151 REV D	1	✓ PO042567	J21867-16	13.36	Pounds
	D135-1027-153 REV B	1	✓ PO042567	J21867-10	14.57	Pounds
	D135-1027-153 REV B	2	✓ PO042567	J21867-15	29.14	Pounds
	D135-1027-153 REV B	1	✓ PO042567	J21867-8	14.57	Pounds
	D135-1027-153 REV B	1	✓ PO042567	J21867-9	14.57	Pounds
	D135-1027-251 REV D	1	✓ PO042567	J21867-5	16.21	Pounds
	D135-1027-251 REV D	1	✓ PO042567	J21867-6	16.21	Pounds
2	PALETTE	1			20.00	Pounds
	D135-1027-251 REV D	3	✓ PO042567	J21867-14	48.64	Pounds
	D135-1027-251 REV D	1	✓ PO042567	J21867-7	16.21	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-1	19.81	Pounds
	D135-1027-253 REV C	2	✓ PO042567	J21867-13	39.62	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-2	19.81	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-3	19.81	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-4	19.81	Pounds

Carrier:**Phone:****Way Bill:**

Journey Freight
1-888-633-1252 #3221

Fob:**Freight Charges:**

Fob Lanoraie
Collect

Total Of Packages :

2 PALETTES
96 X 32 X 36
96 X 32 X 36

Total Weight:

369.06 #

Carrier : Journey Freight

Shipper : Tube Caron Inc.

Declared Value :

(No Additional Insurance Required)

Not Applicable For Insurance Purposes

14-03-2019

CERTIFICATE OF CONFORMANCE

CUSTOMER : Dart Aerospace

DATE : March 21, 2019

P.O.# PO042567

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

PART NO.	QTY.	DRAWING NO. / REV.
D135-1027-253 ✓ MID HEIGHT AFT XTUBE	6 ✓ <i>PD</i>	D135-1027-253 / REV.C
D135-1027-153 ✓ MID HEIGHT FWD XTUBE	5 ✓	D135-1027-153 / REV.B
D135-1027-151 ✓ STD HEIGHT FWD XTUBE	3 ✓	D135-1027-151 / REV.D
D135-1027-251 ✓ STD HEIGHT AFT XTUBE	6 ✓	D135-1027-153 / REV.D

Sincerely,

Kevin Gadoury

Kevin Gadoury

DART AEROSPACE LTD		Work Order: 191900
Description: MID HEIGHT AFT CROSSTUBE		Part Number: D135-1027-253
Inspection Dwg: D135-1027-253	Rev: B/C	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.550" TYP	+/-0.005"	3.549/3.529	✓			
8.23" TYP	+/-0.030"	8.70 / 8.70	✓			
12.08" TYP	+/-0.030"	12.08/12.08	✓			
2.19" REF	+/-0.030"	2.19/2.19	✓			
3.13" TYP	+/-0.030"	3.127/3.125	✓			
Ø.194" THUR 2PL	+0.006" -0.001"	0.194-0.196	✓			
Ø.194" THUR	+0.006" -0.001"	0.194-0.197	✓			
17.0" 2PL	+/-0.100"	17 / 17	✓			
Ø.313" THUR 6PL	+0.006" -0.001"	0.314	✓			
Ø.670" THUR 2PL	+0.006" -0.001"	0.674	✓		CALIPER	

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.197"	0.197	0.197	0.195	0.196				
21" L	0.197"	0.203	0.212	0.206	0.201				
21" R	0.197"	0.196	0.207	0.196	0.202				
CENTER OF BEND L	0.197"	0.182	0.213	0.211	0.206				
CENTER OF BEND R	0.197"	0.186	0.215	0.192	0.201				

OUTSIDE DIAMETER MEASUREMENTS

LOCATION	DWG DIM	M1	M2				
CL	3.543"						
CENTER OF BEND	3.543"						
CENTER OF BEND	3.543"						

CRUSHING

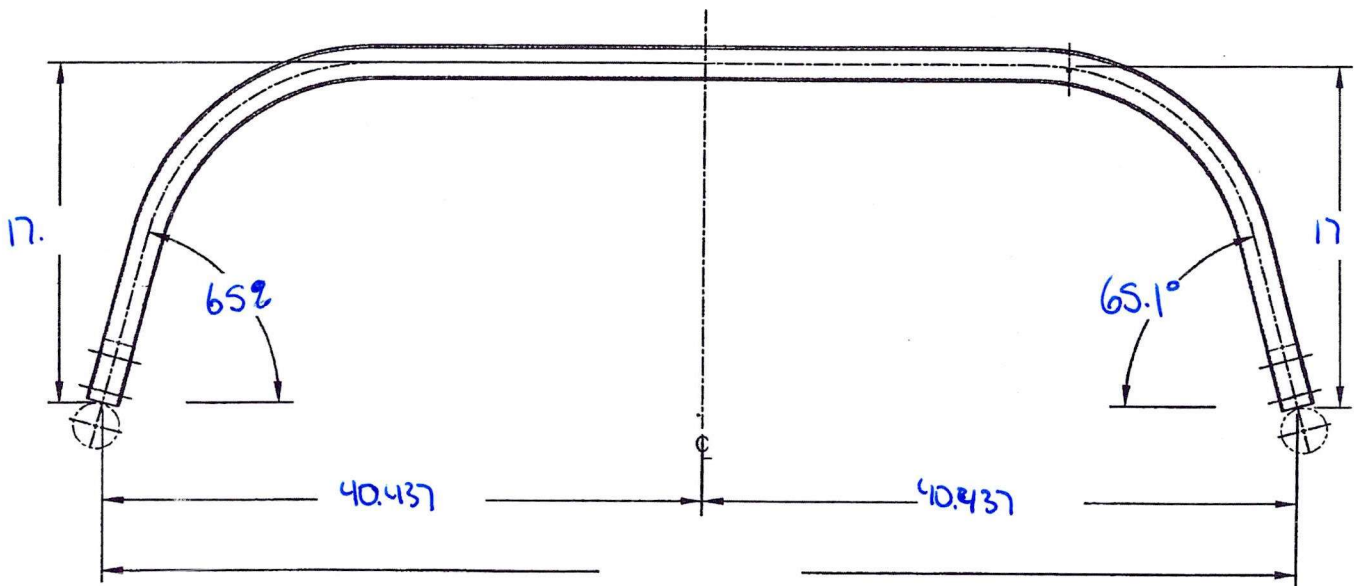
	SIDE A	SIDE B
MAX 2%	.13%	.18%

TWIST

	SIDE A	SIDE B
MAX 0.25"		

DART AEROSPACE LTD		Work Order: 191900
Description: MID HEIGHT AFT CROSSTUBE		Part Number: D135-1027-253
Inspection Dwg: D135-1027-253 Rev: B		Page 2 of 2

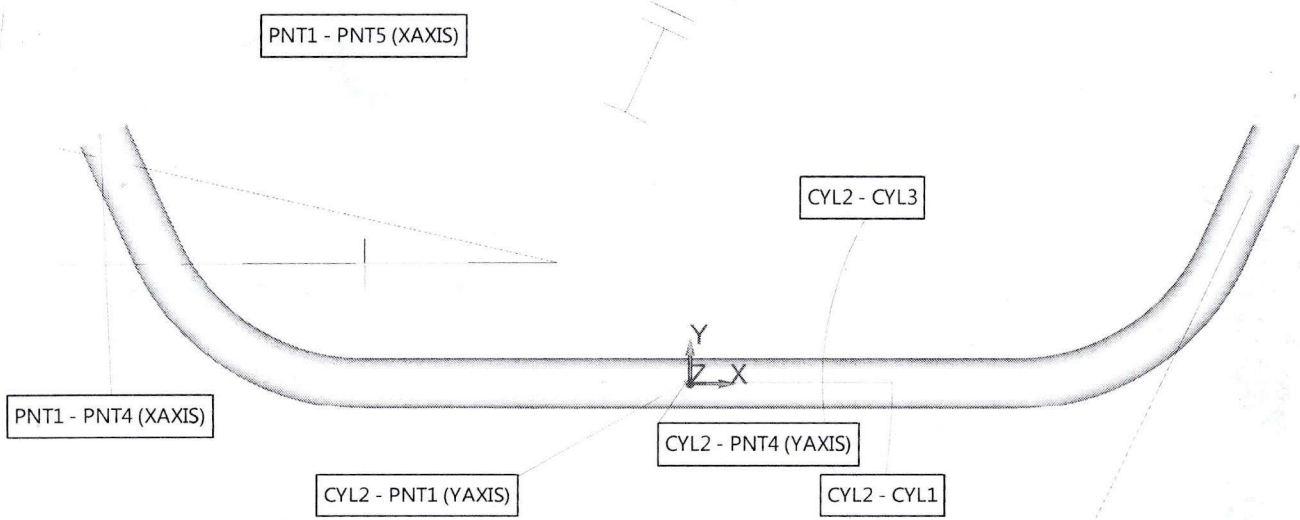
Required Dimension	Min	Max
Height	16.87"	17.13"
1/2 Span	40.28"	40.54"
Angle	64°	66°
Total Span	80.56"	81.08"
Bending Passes		
Crushing	0%	2%
Twist	0.0"	0.25"



Measured by:		Checked by: PD	QC Inspector:
Date:		Date: 17.04.04	Date:

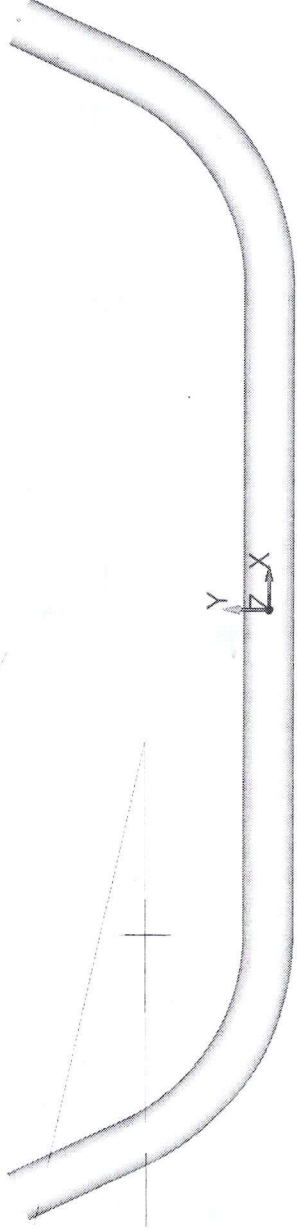
Engineering Approval: (If necessary)		Date:
--	--	--------------

Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	



podmis		PART NAME : D135-1027-253_Pliage+Coupe				mars 09, 2019		14:42	
		REV NUMBER : Rev.B		SER NUMBER : 3164469		STATS COUNT : 1			
∠	DEG	ANGL1 - CYL2 TO CYL1							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	-64.9992	0.5000	0.5000	-64.6878	0.3114	0.0000			
∠	DEG	ANGL3 - CYL2 TO CYL3							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	64.9992	0.5000	0.5000	64.8381	-0.1611	0.0000			
↔	IN	DIST1 - PNT1 TO PNT4 (XAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	80.8110	0.2500	0.2500	80.9657	0.1547	0.0000			
↔	IN	DIST2 - CYL2 TO PNT1 (YAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	17.0010	0.1300	0.1300	16.8863	-0.1147	0.0000			
↔	IN	DIST3 - CYL2 TO PNT4 (YAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	17.0010	0.1300	0.1300	16.9767	-0.0243	0.0000			
↔	IN	DIST4 - PNT1 TO PNT5 (XAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	40.4055	0.1300	0.1300	40.4829	0.0774	0.0000			

PNT4 - PNT5 (XAXIS)



↔	IN	DIST5 - PNT4 TO PNT5 (XAXIS)				
		NOMINAL	+TOL	-TOL	MEAS	DEV
AX						
M		40.4055	0.1300	0.1300	40.4829	0.0774
						0.0000



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043076



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043076

PO Date: 4/3/19

Due Date: 4/11/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
APR 10 2019

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192114	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192115		1 X APR 11 2019	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192116		1 X APR 11 2019	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							3	0	3		\$395.63



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Canada

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PURCHASE ORDER

PO043076



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	192117	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed -		4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192118			Firmed -		4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75
3	190489	D135-1027-251	Std Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed -		4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
4	191900	D135-1027-253	Mid Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed -		4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	191901			Firmed -		4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75
Grand Total:										\$1,055.00	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

PO043076



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL

Plex 4/10/19 12:39 PM dart.lavoie.chantal

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39884	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO043076 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES**

ITEM ID: D135-1027-251 STB HEIGHT AFT CROSSTUBE

1 - WORK ORDER ID#: 190489 ✓

ITEM ID: D135-1027-253 MID HEIGHT AFT CROSSTUBE

2 - WORK ORDER ID#: 191900 ✓

3 - WORK ORDER ID#: 191901 ✓

ITEM ID: D206-667-107BL FWD CROSSTUBE - MID HEIGHT 206L / L1 / L3 / L4, BLUE.

4 - WORK ORDER ID#: 192114 ✓

5 - WORK ORDER ID#: 192115 ✓

6 - WORK ORDER ID#: 192116 ✓

ITEM ID: D206-667-207BL

7 - WORK ORDER ID#: 192117 ✓

8 - WORK ORDER ID#: 192118 ✓

Action Taken:					Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-8) AS PER ASTM1417M-16					APR 6 5 2019	DOT-APP 61 53-89 L
NO CRACK FOUND						
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142						
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT-APP 61 53-89	Date: APR 6 5 2019
Name: ANTONINO MARCHETTA		